

Work Order ID 71312

Tuesday, June 28, 2011 9:58:31 AM



Page 1

Item ID: D412-742-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Float Skidtube

Start Date: 6/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: UMF Date: 11-06-28

Tooling:

Date:

Run Start



QC: Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3391	Rev H

100

0.00



DOCUMENT CONTROL

DC

0.00

Memo

Document Control

If D412-742-043 is a W/O on it's own,
Photocopy bluefile and create labels per PPP D412-742-043 CHG004

NA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71312

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Page 2

Item ID: D412-742-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Float Skidtube

Start Date: 6/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.
A/R ☐ Sikaflex-241/-291 M118393
Expiry date: 12/02

2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube, hand tighten only bolts with no sikaflex.

A/R ☐ Sikaflex-241/-291 M118393
Expiry date: 12/02

3-Remove "T" pins once sikaflex is dry.

4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.
A/R ☐ LPS Procyon M114596

1 ϕ M1109119

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NOTE: Date & initial all entries

Work Order ID 71312

Tuesday, June 28, 2011 9:58:32 AM



Page 3

Item ID: D412-742-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Float Skidtube

Start Date: 6/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 11/02/11

(46)

130

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-742-043

Location:

PPP Rev: PPA 71322

11/9/22 @

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/27
MF 11-09-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 28, 2011 9:58:28 AM

Page 1

Work Order ID: 71312

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube


Start Date: 6/28/2011

Required Date: 7/28/2011


Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A 05.10.13 New Issue KJ/JLM
IPP Rev B 06.02.13 ECN 773 dwg @ rev.D EC
IPP Rev: C 07-05-28 As per Rev F JLM
IPP Rev: D 07-12-04 ECN 1072 DD verified by: JLM
IPP Rev: E 08-09-08 ecn 08-510 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C4A  BOLT		Purchased	No			110	Each	2,162.000	24	24		11/07/06	

Location	Loc Qty	Loc Code
ST350	2162	
117313	2	
117688	776	
117795	500	
117872	22	
118012	500	
118112	362	

AN3C6A  BOLT		Purchased	No			110	Each	264.0000	12	12		11/07/06	
--	--	-----------	----	--	--	-----	------	----------	----	----	--	----------	--

Location	Loc Qty	Loc Code
FP-A	1	
111982	1	
ST351	263	
111982	2	
116419	23	
116549	2	
116704	12	
117514	24	
117619	50	
117688	100	
117872	50	

W/O:		WORK ORDER CHANGES					
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Picklist Print

Page 2

Tuesday, June 28, 2011 9:58:28 AM

Work Order ID: 71312

Parent Item: D412-742-043



Parent Item Name: Replacement Float Skidtube

Start Date: 6/28/2011

Required Date: 7/28/2011



Start Qty: 1.00



Required Qty: 1.00



AN3C7A	Purchased	No	110	Each	135.0000	8	8
							
BOLT							



Location Loc Qty Loc Code



ST351	123	
113149	14	
116169	1	
117313	58	
117688	50	
ST352	12	
117619	12	

AN960C10L	NAS1149C0332 R	Purchased	No	110	Each	0.0000	44	44
								
washer								

D3391-021		Manufactured	No	110	Each	0.0000	1	1
								
Fwd Tube Assembly								

D3391-023		Manufactured	No	110	Each	0.0000	1	1
								
Mid Tube Assembly								

D3391-025		Manufactured	No	110	Each	0.0000	1	1
								
Aft Tube Assembly								

D3564-1		Manufactured	No	110	Each	2.0000	1	1
								
Wearshoe								

Location Loc Qty Loc Code

FG	2	
33798	2	

Tuesday, June 28, 2011 9:58:28 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, June 28, 2011 9:58:28 AM

Work Order ID: 71312

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 6/28/2011

Required Date: 7/28/2011

Start Qty: 1.00

Required Qty: 1.00

D3564-3

Manufactured No

110

Each

12.0000

1

1



Wearshoe



all 11/09/19

Location

Loc Qty

Loc Code

FG

2

33764

2

1371525

x1

FP019

10

64748

3

66000

4

69290

3

D3564-5

Manufactured No

110

Each

26.0000

1

1



Wearshoe



all 11/07/06

Location

Loc Qty

Loc Code

FG

2

34806

2

FP019

24

68960

2

70864

22

y1

D3566-1

Manufactured No

110

Each

12.0000

2

2



Gasket



all 11/07/06

Location

Loc Qty

Loc Code

FP015

12

68924

2

69279

10

x2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 4

Tuesday, June 28, 2011 9:58:28 AM

Work Order ID: 71312



Parent Item: D412-742-043



Parent Item Name: Replacement Float Skidtube

Start Date: 6/28/2011

Required Date: 7/28/2011

Start Qty: 1.00

Required Qty: 1.00

D3566-5

Manufactured No

110

Each

18.0000

1

1



41 6/27/06

Gasket

Location

Loc Qty

Loc Code

FP015

18

68961

18

X1

Tuesday, June 28, 2011 9:58:28 AM

Shop Packet Print

Page 4

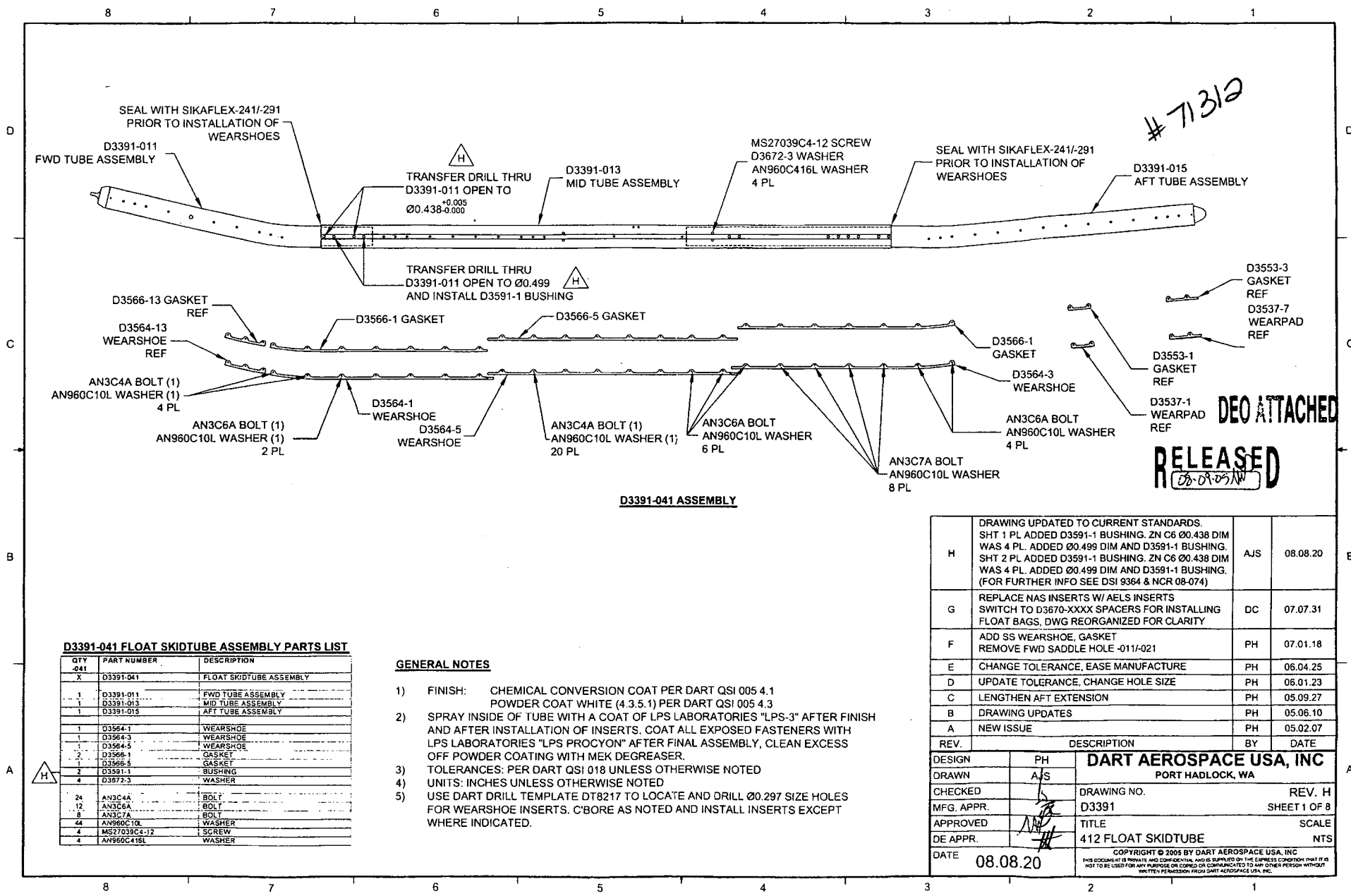
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NOTE: Date & initial all entries



D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3391-041	Float Skidtube Assembly
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
4	D3572-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

REV.	DESCRIPTION	BY	DATE																										
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20																										
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31																										
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18																										
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25																										
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23																										
C	LENGTHEN AFT EXTENSION	PH	05.09.27																										
B	DRAWING UPDATES	PH	05.06.10																										
A	NEW ISSUE	PH	05.02.07																										
<table border="1"> <tr> <td>DESIGN</td><td>PH</td><td colspan="2" rowspan="2">DART AEROSPACE USA, INC PORT HADLOCK, WA</td></tr> <tr> <td>DRAWN</td><td>AJS</td></tr> <tr> <td>CHECKED</td><td></td><td>DRAWING NO. D3391</td><td>REV. H</td></tr> <tr> <td>MFG. APPR.</td><td></td><td></td><td>SHEET 1 OF 8</td></tr> <tr> <td>APPROVED</td><td></td><td>TITLE</td><td>SCALE</td></tr> <tr> <td>DE APPR.</td><td></td><td>412 FLOAT SKIDTUBE</td><td>NTS</td></tr> <tr> <td>DATE</td><td>08.08.20</td><td colspan="2"> COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. NO PART OF THIS DOCUMENT IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. </td></tr> </table>				DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA		DRAWN	AJS	CHECKED		DRAWING NO. D3391	REV. H	MFG. APPR.			SHEET 1 OF 8	APPROVED		TITLE	SCALE	DE APPR.		412 FLOAT SKIDTUBE	NTS	DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. NO PART OF THIS DOCUMENT IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

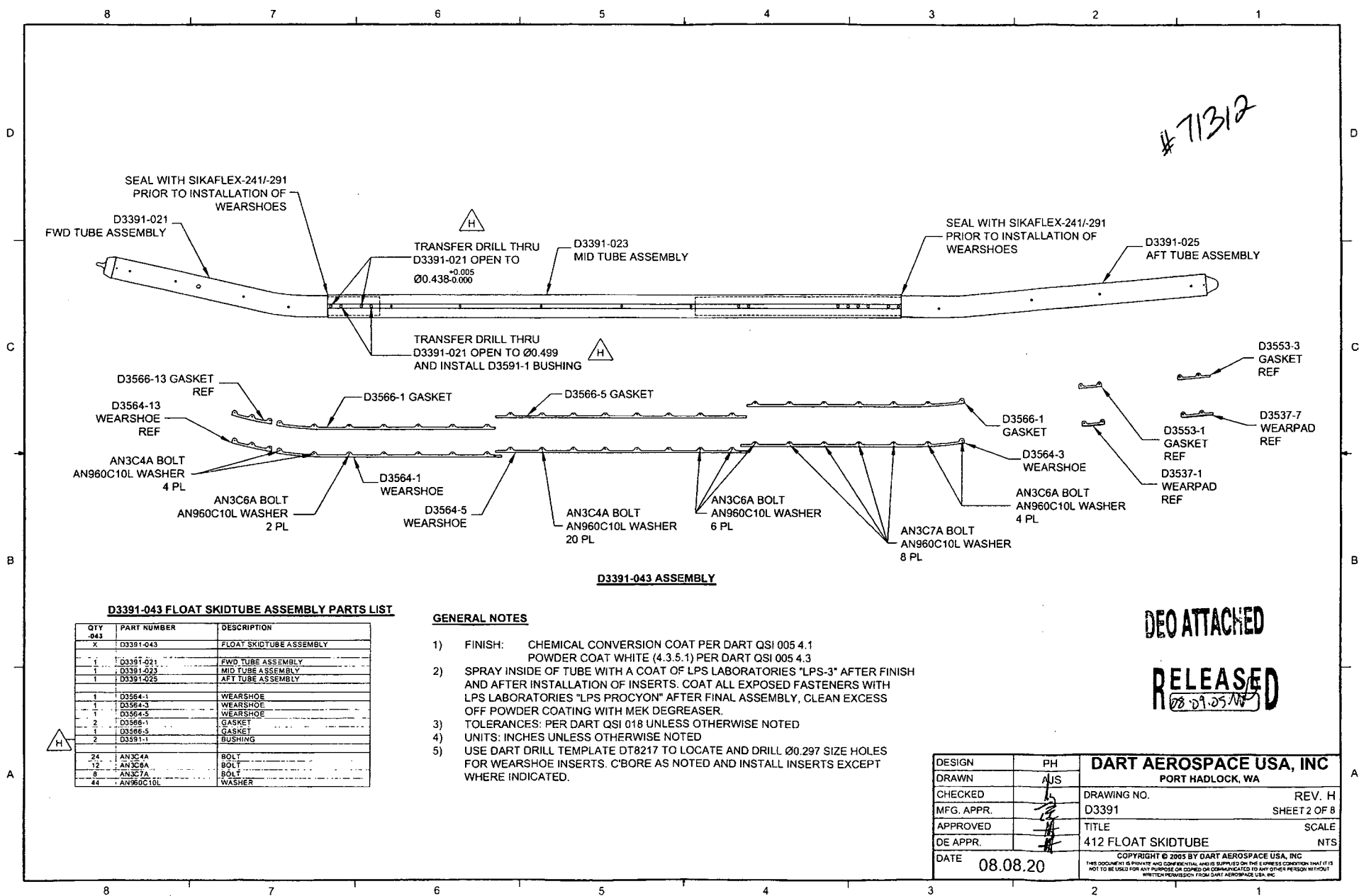
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

#71312



D3391-043 ASSEMBLY

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C-BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

DEO ATTACHED
RELEASED
08-09-2008

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC</small>	

Dart Aerospace Ltd

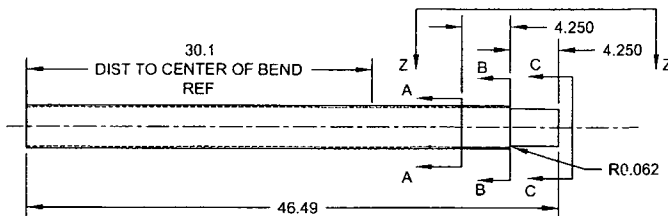
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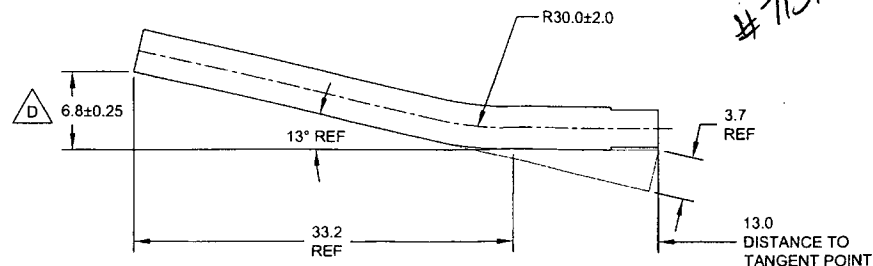
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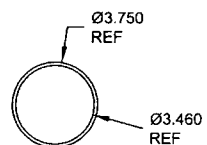
NOTE: Date & initial all entries



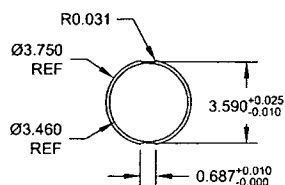
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



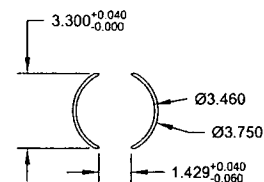
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



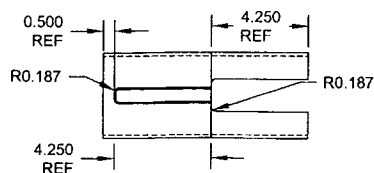
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

DEO ATTACHED
RELEASED
28 JAN 1971

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D3391	SHEET 3 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	412 FLOAT SKIDTUBE	NTS
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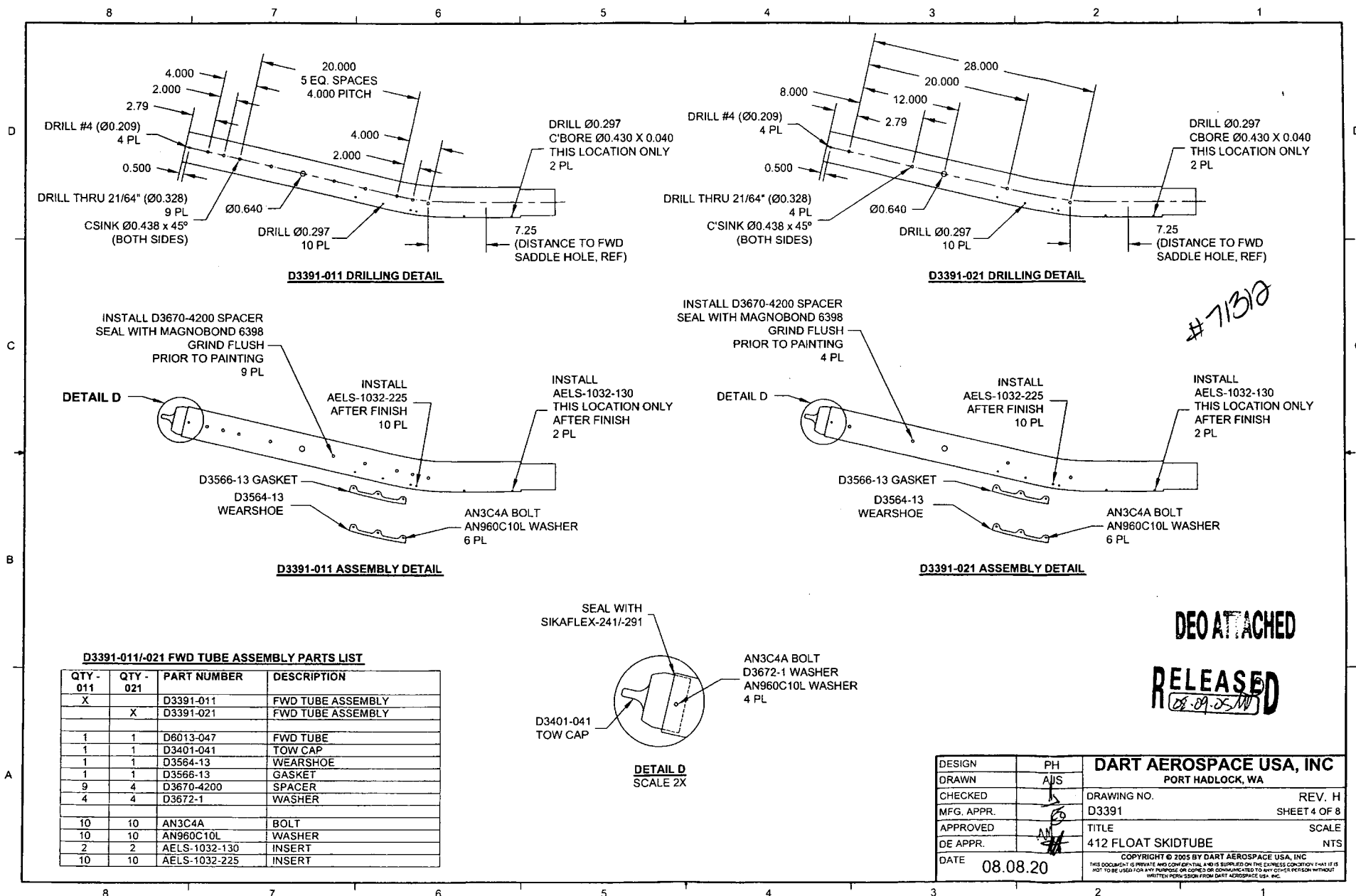
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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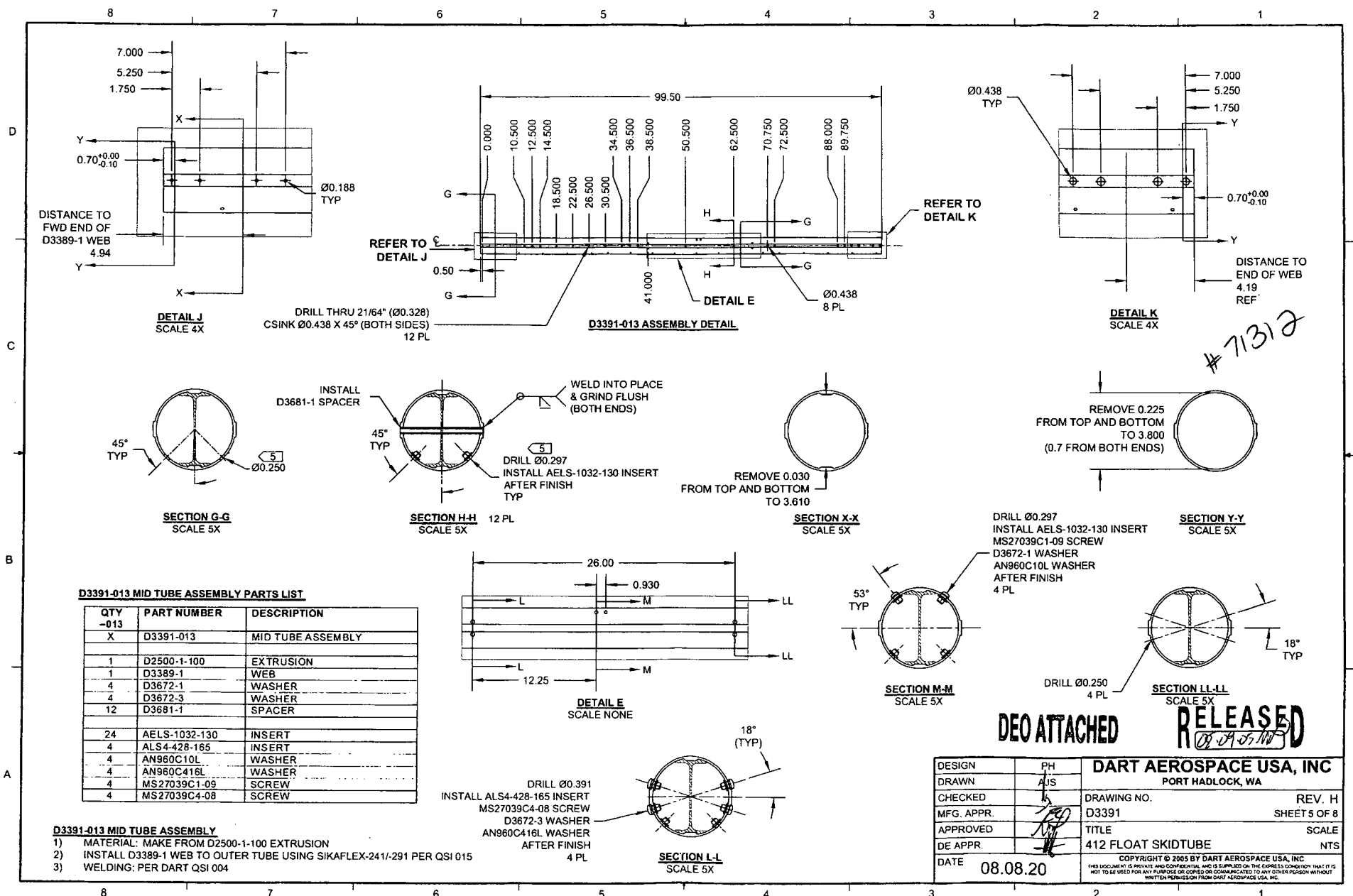
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



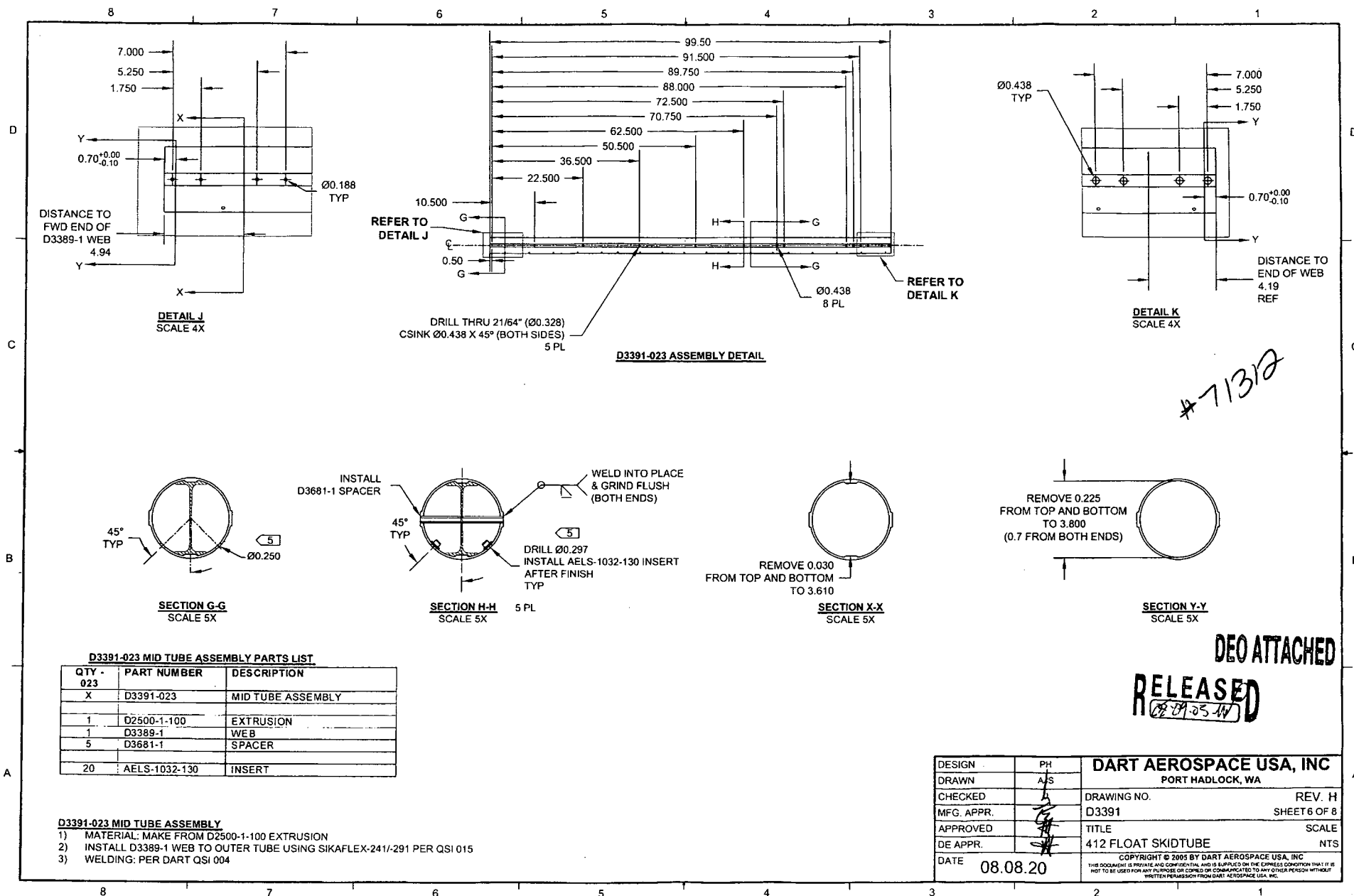
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

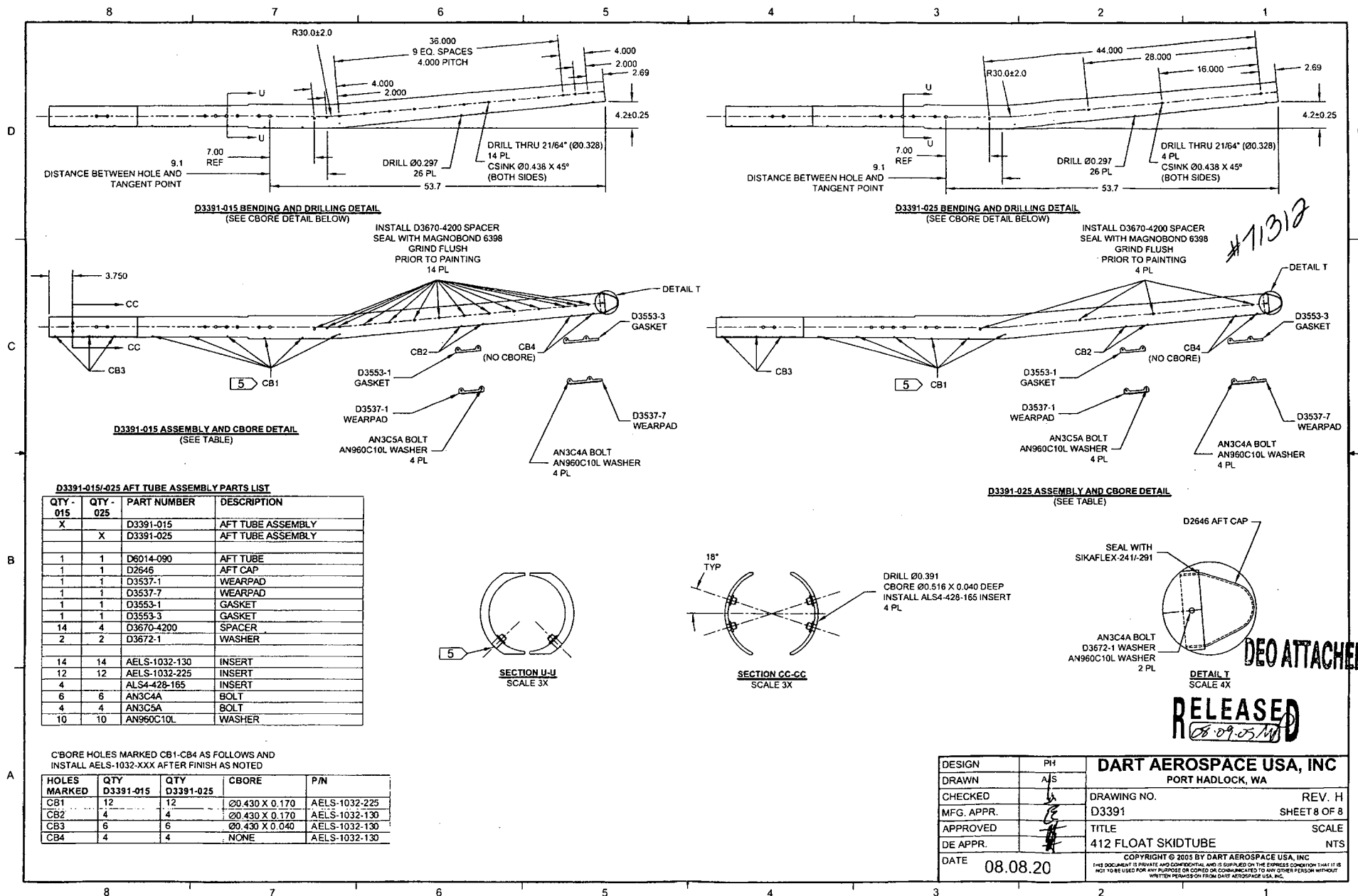
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>h</i>	MFG. APPR. <i>h</i>	APPROVED <i>MP</i>		DE APPR. <i>h</i>		
DATE 09.09.23	DATE 04.09.24	DATE 09/09/25	DATE 09/09/30		DATE 09/09/30		

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
 OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
 2010-02-02

MP

#7132

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries